

Claims

1. A vehicle upholstery member having an air bag door equipped with a fabricated skin, wherein a portion of the back surface of the skin corresponding to the portion where the vehicle air bag is installed is formed with a break-scheduled line that is not so deep as to reach the surface of the skin and adapted to assume a substantially V-shaped groove shape when the skin is bent with its back surface convexed.

2. The vehicle upholstery member having the air bag door according to claim 1, wherein the back surface of the skin having the break-scheduled line is rendered substantially flat when the skin is flattened.

3. The vehicle upholstery member having the air bag door according to claim 1 or claim 2, wherein the break-scheduled line is constructed of one or more straight line(s) and a straight line or a curve vertically or diagonally intersecting the one or more straight line(s).

4. The vehicle upholstery member having the air bag door according to any one of claims 1 to 3, which meets the relationship of $t1 \times 0.3 < t2 < t1 \times 0.7$ when the skin takes $t1$ (mm) in thickness and the break-scheduled line takes $t2$ (mm) in depth.

5. The vehicle upholstery member having the air bag door according to any one of claims 1 to 4, further comprising a foam layer and a substrate accommodating the air bag on the back side of the skin.

6. The vehicle upholstery member having the air bag door according to any one of claims 1 to 5, wherein the skin is a powder slush molded product using a thermosetting resin or a thermoplastic resin as a molding material.

7. A method of producing a vehicle upholstery member having an air bag door equipped with a fabricated skin, comprising the following steps (A) to (C) in order:

(A) substantially flatly mounting the skin on a support base;

(B) forming a break-scheduled line that is not so deep as to reach the surface of the skin with a cutting blade; and

(C) measuring the depth of the break-scheduled line or the thickness of the remaining portion with the incision of the break-scheduled line opened.

8. The method of producing the vehicle upholstery member having the air bag door according to claim 7, wherein the skin is aspirated from the back surface side and fixed on the support base.

9. The method of producing the vehicle upholstery member having the air bag door according to claim 7 or claim 8, wherein, at the step (C), a protrusion arranged in the support base is moved up to a given height and pressed upward against the skin to thereby open the incision of the break-scheduled line.

10. The method of producing the vehicle upholstery member having the air bag door according to any one of claims 7 to 9, wherein, at the step (B), the break-scheduled line is formed while detecting the altitude of the cutting blade.

11. The method of producing the vehicle upholstery member having the air bag door according to any one of claims 7 to 10, further comprising the step of detecting the state of the cutting blade prior to the step (B).

12. The method of producing the vehicle upholstery member having the air bag door according to any one of claims 7 to 11, wherein, at the step (C), the depth of the break-scheduled line or the thickness of the remaining portion is measured with an optical film thickness measurement device.

13. A method of producing a vehicle upholstery member having an air bag door equipped with a fabricated skin, comprising the following steps (a) to (c):

(a) partially or entirely bending the skin with its back surface convexed;

(b) forming a break-scheduled line that is not so deep as to reach the surface of the skin with a cutting blade; and

(c) measuring the depth of the break-scheduled line or the thickness of the remaining portion with the incision of the break-scheduled line opened.

14. The method of producing the vehicle upholstery member having the air bag door according to claim 13, wherein, at the

step (a), the skin is mounted on a substrate and pressed with a protrusion arranged in the substrate for bending the skin with its back surface convexed.

15. The method of producing the vehicle upholstery member having the air bag door according to claim 13 or claim 14, wherein, at the step (a), the protrusion is moved up and pressed upward against the skin.

16. A device for producing a vehicle upholstery member having an air bag door equipped with a fabricated skin, comprising:

a support base for substantially flatly mounting the skin thereon;

a cutting blade for forming a break-scheduled line in the skin; and

measuring means for measuring the depth of the break-scheduled line or the thickness of the remaining portion,

wherein the measuring means is used to measure the depth of the break-scheduled line or the thickness of the remaining portion, with the incision of the break-scheduled line opened.

17. The device for producing the vehicle upholstery member having the air bag door according to claim 16, wherein the support base is equipped with a protrusion for upward pressing the skin, and the protrusion is moved up to a given height and pressed upward against the skin.

18. The device for producing the vehicle upholstery member having the air bag door according to claim 16 or claim 17, wherein the protrusion is constructed of one or more linear object(s) and a linear object or a curved object vertically or diagonally intersecting the one or more linear object(s).

19. The device for producing the vehicle upholstery member having the air bag door according to any one of claims 16 to 18, further comprising position-detecting means for detecting the altitude of the cutting blade.

20. The device for producing the vehicle upholstery member having the air bag door according to any one of claims 16 to 19, further comprising state-detecting means for detecting the state of the cutting blade.

21. The device for producing the vehicle upholstery member having the air bag door according to any one of claims 16 to 20, wherein the support base is provided with a suction portion for fixing the skin therein.